SR00098NY

(DZYZEN)

SIC

MADE IN CANADA

401

B66796

EC130B4

			DQA:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

NCR: Y	es / No				WORK ORDER NON-C	JUNFUR	AVIAINCE / UP	UAEE	QA Closed:	Dat	te:
Work Ordei	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0.				Use-as-is Work Order Update	The	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	g Desc	ription	Date	Verificatio	n QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material											
Setup							ļ				
Other											
Process											
Supplier											
raining	$\dashv$										
Jnapproved		<u> </u>				AULT CAT	<u> </u>		<u> </u>		
Landin	g Gear				General	AOLI CAI	LOOKI			···	• • • • • • • • • • • • • • • • • • • •
Γ	Bending			Γ	Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Hardv			Over/Under	tolerance	Temperature/Cure
ľ	Cracks				Broken/Damaged	$\vdash$	tion Incomplete		Part Incorre		Weld
	Crushed/	Crimped.			Burrs	<b>⊢</b>	ctions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
<b> </b>	Cuffs	•	~. ~	\	Contamination	$\vdash$	tenance		Part Moved	-	<u> </u>
	Heat Trea	it			Countersink	Mislal	peled `		Positioned \	<b>V</b> rong	
Γ	Inspection	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	/Surge	Other
Γ	Ripples in	Bend			Drill Holes	Offset	:				
	Torque W	aves in 8	xtrusio	ո [	Drawing	Out o	f Calibration				
	Turning S	equience			Finish	Out o	f Sequence				

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ord</b> November-16-12				*935	503*							Page 2	
Item ID: Revision ID: Item Name:	D350-600-2 Spacepod, RI	H, AS350/355		Accept	*N900	<b>040</b>	100	)* s	Setup S	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	11/16/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:	_	-		Stant.			
Approvals:			Date:	Tooling: SPC (Y/N):		ite:		ŀ		Start Stop		R1* R2*	
Sequence ID/ Work Center I	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
*190* QC Quality Control		Memo		0.00									

ULZ-11-21

								•	DQA:	Date:	<u> </u>
NCR: Yes	s / No				WORK ORDER NON-C	CONFORI	MANCE / UP		QA Closed:	Date:	
Work Order:				!	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No NCR No					Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite					Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial			Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling	]										
Operator											
Material	_									·	
Setup											
Other											,
Process											
Supplier											
Training											
Unapproved			-	]							

Bend Bending Grain Pressure/Forced Ovalized Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Mislabeled Heat Treat Positioned Wrong Countersink Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

**FAULT CATEGORY** 

General

**Landing Gear** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde November-16-12				*935				1.0		Page 3	}		
Item ID: Revision ID: Item Name:	D350-600-2 Spacepod, R	H, AS350/355		Accept	*N900	<b>040</b>	100	)* s	etup	Start Stop	ı u .	S1* S2*	
Start Date: Required Date: Reference:	11/16/12 11/16/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		_		<b>S</b> 4 4			
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ite:		ŀ	Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II	D	Operation Description Pick Kit		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp	
*200* Packaging		Memo		0.00									-

REMOVE PARTS FROM 130 KIT, AND RETURN TO STK, RECORD ALL P/N'S, B/N'S AND QTYS:

Packaging

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM					
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION			AGA	NINST DE	PARTMENT	PROCESS	
Part NCR	No.					Rework Skid-tube Crosstu  Scrap Machining Small F  Use-as-is Thermoforming Finish  Work Order Update Large Fab Compose  ription of work order update Initial Action						Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		•											
Operator													
Material													
Setup													
Other													
Process													
Supplier							1						
Training							ļ						
Unapproved													
						F	AUL	T CATE	GORY				
Land	ing (	Sear				General		-					<del>_</del>
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.					Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	Maintenance Part Moved				_
		Heat Trea	at			Countersink		<del></del>			Positioned V	Vrong	
	Inspection Strip in Tube					Cut Too Short Misread						Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orden November-16-12				*935						Page 4		
Item ID: Revision ID: Item Name:	D350-600-2- Spacepod, RI-			Accept	*N900	040	100	)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	11/16/12 : 11/16/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Approvals:	Process Plan:		Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp

												DQA:	Date:	•
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFOR	MANCE / UP	DATE			
												QA Closed:	Date:	
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part NCR							Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desc	rip	ition of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		.0	r Non-conformance	Chief Eng Description			ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining														
				-			FA	<b>AUL</b>	T CATE	GORY			<u> </u>	
Land		7			-		General		i			,	<b></b>	_
		Bending Centre No Cracks	ot Concer	ntric to (	o/s	Bend BOM/Route Broken/Damaged			Grain Hardwa Inspecti	re on Incomplete		Ovalized Over/Under Part Incorred	<del></del>	Pressure/Forced Temperature/Cure Weld
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	L	Cuffs					Contamination		Mainte			Part Moved		
		Heat Trea			-		Countersink		Mislabe			Positioned V		, ,
	<b></b>	Inspection	•	Tube	-	_	Cut Too Short	$\vdash$	Misread	1		Power Loss/	Surge	Other
		Ripples in				_	Drill Holes	-	Offset					
	<u> </u>	Torque W		xtrusior	י [	$\overline{}$	Drawing	$\vdash$	1	Calibration				
	1	Turning S	equence		1		Finish		Out of S	Sequence				

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

230

QC21- Final Inspection - Work Order Release

0.00

\*230\*

Memo

0.00

**Quality Control** 

MC2 12-11-51

	WORK ORDER MON. CO.		DQA:	Date:
NCR: Yes / No	WORK ORDER NON-CON	IFORMANCE / UPDATE	QA Closed:	Date:
Work Order:	DISPOSITION	AGAIN	ST DEPARTMENT/PR	OCESS
TOTAL OTALET.	Rework	Skid-tube Crosstu	be V	Vater Jet

Work Order	r:				DISPOSITION	AGAINST DEPARTIVIENT					/PROCESS	
Part N	0				Rework Scrap Use-as-is		Machining Small Thermoforming Finis		Crosstube Small Fab Finishing	<b>⊣</b>	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N				<del></del>	Work Order Update	-		Large Fab	Composite	٦	Supplier	
Root				Descri	ption of work order update	Ir	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other	_											
Process												
Supplier	_											
Training												
Unapproved												
						AUL1	T CATE	GORY			· · · · · · · · · · · · · · · · · · ·	
Landin	>			_	General					<del></del>	_	<del></del> 1
-	Bending			<u> </u>	Bend	$\vdash$	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
_		ot Conce	ntric to (	o/s	BOM/Route	$\mathbf{H}$	Hardwa		<u> </u>	Over/Under		Temperature/Cure
_	Cracks				Broken/Damaged	$\vdash$		ion Incomplete	_	Part Incorre	ct	Weld
	Crushed	Crimped.		<u> </u>	Burrs	-		ions Incomplete/	'Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination		Mainte			Part Moved		
	Heat Tre			L	Countersink	$\vdash$	Mislabe			Positioned	_	_
<u> </u>	Inspection	•	Tube		Cut Too Short	$\vdash$	Misread	t		Power Loss,	'Surge	Other
	Ripples ii				Drill Holes	Offset						
<u> </u>	Torque V	Vaves in E	extrusion	า  _	Drawing	Out of Calibration						
	Turning S	Sequence		L	Finish	Out of Sequence						
	Wave/Tv	vist in Tul	oe		Folio		Outside	Dimensions				

DQA:

## Picklist Print

November-16-12 9:47:03 AM

Work Order ID:

93503

Parent Item:

D350-600-242

Parent Item Name:

Spacepod, RH, AS350/355

**Start Date:** 11/16/12

Required Date: 11/16/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A07.03.07 new issue

EC

IPP rev B 07.04.16 reformat, D3188 rev.E EC

IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove D3188-2m add D3188-6 DD 10.04.07 verified

by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			150	Each	389.0000	28	28			
Insert													
\(\frac{1}{2}\)				Location		Loc Qty	1	oc Code					
				ST280		205							
		$\wedge$	1	119	9084	116							
/ /	/ /	18U 1	_ \		0671	89							
\ \		AN A ILA	We -	ST281		44							
		(40 /1/20	ر کے م		0807	36							
		1,00 2,0	DON		0837	8							
<b>'</b> \ '	1100	c <sub>t</sub> V	8	ST282	10/0	140							
				12	1269	140	Б.	02.0000					
AN526C832R10	Ø,	Purchased	No			150	Each	83.0000	10	10			
Screw	\								v	a ngganaran in	· · · · · · · · · · · · · · · · · · ·	- /	
\				Location		Loc Qty	<u>I</u>	Loc Code					
`				ST345		83							
					5101	5			**************************************				
A N. # 2 C C C C 2 2 D 4 4			NI.	11	8853	78	Cash	260,0000					
AN526C832R14		Purchased	No			150	Each	360.0000	2	2			
Screw							_		·		····	· · · · · · · · · · · · · · · · · · ·	
	/			Location		Loc Qty	_	Loc Code					
				ST348		360							
				10	4916	360				<del></del>			
AN526C832R24 screw		Purchased	No			140	Each	77.0000	4	4			
				Location		Loc Oty	3	oc Code					
				ST348		77						·	
					8870	77						٤	

												DQA:	Date:	<u> </u>
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
												QA Closed:	Date:	•
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part NCR							Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
						_						· _ •		
Root         Description of work order update         Initial         Action           Cause         Date         Step         Qty         or Non-conformance         Chief Eng         Description												Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining				3.7						2 0 0 0 1				·
napproveu	l_	l		1			F	<u>l</u> AUL	T CATE	GORY				1
Land	ng (	Gear					General							
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Grain Hardware Inspection Incomplete Instructions Incomplete/Uncle Maintenance Mislabeled Misread			nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in					Drill Holes		Offset		<del></del>			
	L	Torque W		xtrusion	۱ [		Drawing			Calibration				
	Turning So	equence				Finish		Out of S	equence					

Wave/Twist in Tube

November-16-12 9:47:03 AM

Work Order ID:	93503							
Parent Item:	D350-600-242					Start 1	Date: 11/16/12	Required Date: 11/16/12
Parent Item Name:	Spacepod, RH, AS350/355					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
AN960JD10 Washer	NAS1149D0363J Purchased	No		150	Each	0.0000	2	2
AN960JD516 Washer	NAS1149D0563J Purchased	No	·	140	Each	2.0000	1	1
- \ W	A Pulle 150-100 DS	F	<u>Location</u>	Loc Qty		Loc Code		
/ '	SU Walle		ST338 1069059	2 2				
AN960JD8	NAS1149DN832J Purchased	No		140	Each	0.0000	20	20
Washer <b>D130-780-042</b> Spacepod, RH	Manufactured	No			Each	2.0000		150
			Location	Loc Oty		Loc Code		
5m0			FG117 66796 71478	2 1 1				
D2179	Manufactured	No		140	Each	27.0000	2	2
Doubler			<b>Location</b>	Loc Qty		Loc Code	Action when world a large of the community of	
			ST006	27				···
			35432	27				<del>_</del>
D2228  Bracket Plate	Manufactured	No		150	Each	37.0000	4	4
			Location	Loc Qty		Loc Code		
$\sim$			ST007	37				
			64427	3				
			73380	34				

												DQA:	Da	ate:	3
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE		•		•	
												QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION				AGAINST D	ΕI	PARTMENT	PROCESS		
WOIR OIG	٠					Rework	1		Skid-tube	Crosstube	٦		Water Jet	· [	Engineering
Part l	No.					Scrap		] ,	Machining	Small Fab	$\dashv$	Pro	d. Eng. Coor	-	Quality
,						Use-as-is	1		noforming	Finishing	ㅓ		e/Packaging	-	Other
NCR	No.					Work Order Update	1		Large Fab	Composite	$\dashv$		Supplier	-	
						' <u> </u>	,			· <b>L</b>					· · · · · · · · · · · · · · · · · · ·
Root					Descri	ption of work order update		Initial	Ac	tion	П	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Desc	ription		Date	Verification	on_	QC Inspector
Doc/Data	Ш		1												
Equip/Tooling								'						1	
Operator	Ш	1	ť												
Material	Ш														
Setup	Ш						ŀ								
Other											-				
Process			İ						•						
Supplier											-				
Training											-				
Unapproved															
						F	AUI	T CATE	GORY						
Landi	ng G	Gear				General		-				•		_	
	Ш	Bending				Bend	L	Grain				Ovalized		L	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
	Ш	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
1	H	Cuffs				Contamination		Maintenance			Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

November-16-12 9:47:03 AM

Work Order ID: Parent Item: Parent Item Name:	93503 D350-600-242 Spacepod, RH, AS350/355							<b>Date:</b> 11/16 <b>Qty:</b> 1.00	6/12	Required Date: 11/16/12 Required Qty: 1.00
D2237 Striker Plate	Manufactured	No			140	Each	55.0000	2	2	
			Location		Loc Qty		Loc Code			
			ST007		55					
				66139	1					
\				85476	1					
	1 1			89925	13					
,	$\langle \langle \langle \langle \langle \rangle \rangle \rangle \rangle$			91815	40			<del></del>		
D2464 3/4 Seal	Manufactured Manufactured	No			150	f	548.8706	10.8	11.3684	21 
37-364	Manufactured Ward Manufactured Ward Manufactured		Location	<u>!</u>	Loc Oty		Loc Code			
\	01 2X/20 CX		ST403		548.8706					
\ (	On the Wil			61878	83.6406					
	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			83543	465.23					
D2585 Mounting Channel	Manufactured	No			150	Each	69.0000	2	2	
\			Location	<u>1</u>	Loc Oty		Loc Code			
\			ST012		66					
\	•			73297	2					
. /	\			86945	24					
N /				91960	20					
				92203	20			-		
			WA		3					
	. \			89387	3					
D2586 Door Latch	Manufactured	No			150	Each	82.0000	2	2	
			Location	<u>n</u>	Loc Qty		Loc Code			
			FG		10					
				83893	10					
			ST198A		72					
				89150	72					

									DQA:	Date:	`.
NCR: Yes	s / No				WORK ORDER NON-C	CONFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is		Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.					Work Order Update	lileii	Large Fab	Composite	Nec/3to	Supplier	other _
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	J										
quip/Tooling		ļ									
Operator				i							
Material											
etup				i							
Other											
Process											

#### **FAULT CATEGORY Landing Gear** General Bend Pressure/Forced Bending Grain Ovalized BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Maintenance Part Moved Contamination Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Other Cut Too Short Misread Power Loss/Surge Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-16-12 9:47:03 AM

Work Order ID: Parent Item: Parent Item Name:	93503 D350-600-242 Spacepod, RH, AS350/355				Date: 11/16/12 Qty: 1.00	Required Date: 11/16/12 Required Qty: 1.00
D2621 Latch Plate, 350 Spacepo	Manufactured No		150 Ea	ch 42.0000	2	2
Eaten Flate, 330 Spacepo	<b>.</b>	<u>Location</u>	Loc Oty	Loc Code		
		ST014	42			
		86368	10			
\		88616	32			_
D2857-1	Manufaotured No		150 Ea	ch 19.0000	1	1
Hinge Bracket	iviandia da la					
This states		<b>Location</b>	Loc Qty	Loc Code		
\		FG	4			_
\	N / //	82261	4			_
\		ST019	15			
/\		75253	1			_
/ \		82261	2			_
\	<i>N</i> (	85805	12			<u> </u>
D2857-2 \	(   Manufactured No		150 Ea	27.0000	1	1
Hinge Bracket	130.70 2ttzelue				Contract of the second	
\		Location	Loc Qty	Loc Code		
\	10 11 selle	FG	4			
	130/10 210	78904	4			
\	get not	ST019	23			
\	91 7	85806	20			
\		91544	3			<del></del>
D2986	Manufactured No		140 sf	0.0000	5.62 5.9	157895
Black Neoprene Foam 1						
D3015-3	Manufactured No.		130 Ea	ach 187.0000	1	1
Locknut						
		Location	Loc Qty	Loc Code		
		ST023	187			_
		78314	30			area-
		83565	57			_
		91863	100			

												DQA:	Date	:		
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	AANCE / UPD	ATE	•				
												QA Closed:	Date	:		
Vork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part NCR		Use-as-is							Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root					Desc	crip	otion of work order update		nitial	Actio	n	Sign &				
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector		
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved																
							F	AUL	T CATE	GORY						
Land		1			r		General		1			1	_	_		
		Bending Centre No Cracks	ot Concer	ntric to (	D/S	-	Bend BOM/Route Broken/Damaged		Grain Hardwa	re on Incomplete		Ovalized Over/Under Part Incorred	<b>├</b>	Pressure/Forced Temperature/Cure Weld		
	$\vdash$	Crushed/0	Crimped		}		Burrs		1	ions Incomplete/Un	clear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled		
		Cuffs	(r		ŀ		Contamination	$\overline{}$	Mainte			Part Moved				
		Heat Trea	t		İ		Countersink		Mislabe			Positioned V	Vrong			
		Inspection	n Strip in	Tube	ļ		Cut Too Short	П	Misread			Power Loss/	_	Other		
		Ripples in			ļ		Drill Holes	$\vdash$	Offset					1		
		Torque W	aves in E	xtrusion	n		Drawing		Out of (	Calibration				<del>-</del>		
	Γ	Turning Se	equence		ļ		Finish		Out of S	equence						

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-16-12 9:47:04 AM

Work Order ID: Parent Item:	93503 D350-600-242 Spacepod, RH, AS350	0/255						Date: 11/16/12 Qty: 1.00	Required Date: 11/16/12 Required Qty: 1.00
Parent Item Name:		Manufactured	No		110	Each	1.0000	1	1
Spacepod Body	ou 130-750			<u>Location</u> CA	Loc Oty		Loc Code		
D350-600-449 Switch Relocation		Manufactured	No	75462	200	Each	2.0000	50	1
		·		<u>Location</u> FG125	Loc Qty 2		Loc Code		_
€W6⊃ 163538-1		Manufactured	No	, <u>74072</u> 79288	1 1 140	Each	11.0000	2	
Hinge Bracket	•			Location	Loc Oty		Loc Code		32.
	1 0 2 13C	×760		ST056 84029 84630	11 3 8				
D3554-7 Ball Study (	- Bulle	Manufactured	No		140	Each	55.0000	1	1
1 1 1 1/1/	a ethalic			Location ST056 73383 87039 87571	Loc Oty 55 5 20 30		Loc Code		
D3557-1 Bracket	V	Manufactured	No		150	Each	17.0000	1	1
V				<b>Location</b> ST058 73384	<u>Loc Oty</u> 17 17		Loc Code		

													, ,
											DQA:	Date:	* * * * * * * * * * * * * * * * * * * *
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / U	PDATE	QA Closed:	Date:	
		an	-					<u> </u>					
Nork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
						Rework		1	Skid-tube	Crosstube		Water Jet	Engineering
Part	No.			<b></b>		Scrap	4	1	Machining	Small Fab	-₹	d. Eng. Coor.	Quality
NCD	NI.					Use-as-is	4	1	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	IVO.					Work Order Update			Large Fab	Composite	J	Supplier	
Root					Descr	iption of work order update		Initial	Д	Action	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Des	scription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling	-												
perator	$\vdash$												
1aterial	$\vdash$								·				
etup													
ther rocess	$\vdash$												
upplier	$\vdash$												
raining												:	
napproved	$\vdash$												
	1						FAUI	LT CATE	GORY				
Land	ing (	Gear				General		_			_		_
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (	o/s  _	BOM/Route	_	Hardwa			Over/Under		Temperature/Cure
	$\vdash$	Cracks			<u> </u>	Broken/Damaged	<u> </u>	-	on Incomplete		Part Incorre		Weld
	$\vdash$	Crushed/0	Crimped,		<u> </u>	Burrs	$\vdash$	-1	ions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	$\vdash$	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte			Part Moved		
	$\vdash$	Heat Trea		<b>-</b> 1	<u> </u>	Countersink	-	Mislabe			Positioned V		۱
	$\vdash$	Inspection		rube	ļ	Cut Too Short	-	Misread	1	<u></u>	Power Loss/	Surge	Other
	$\vdash$	Ripples in			<u> </u>	Drill Holes	$\vdash$	Offset	· · · · · · · · · · · · · · · · · · ·				
	$\vdash$	Torque W			` <b> </b>	Drawing	$\vdash$	4	Calibration				
		Turning S	equence		L	Finish	L	JOut of S	equence				

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-16-12 9:47:04 AM

Work Order ID: Parent Item:	93503 D350-600-242						Start D	ate: 11/16/12	Required Date: 11/16/12
Parent Item Name;	Spacepod, RH, AS	350/355					Start (	Qty: 1.00	Required Qty: 1.00
D3567-2	1x pulled	Manufactured	No		140	Each	18.0000	1	1
	1/2 gulle2 130780 see	2 Kzane		Location ST055	<u>Loc Qty</u> 18		Loc Code		
K10021 Spacepod Hardware Ki	5W)	Manufactured	No	50375	200	Each	0.0000		1 93575 2
MS20426AD4-5 Rivet	(-241)	Purchased	No		140	Each	4,031.0000	4	4
Rivet				Location	Loc Oty		Loc Code		
				ST317 6874	4031 4031				
MS21042L08 Nut		Purchased	No		150	Each	797.0000	18	18
Nut \				Location	Loc Qty		Loc Code		
· ·				315	9				<del></del> ,
				122452	9				
				ST315 122814	500 500				
				ST317	288				
				122141	288			u	

		,		
NCR:	Yes	/	No	

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA:	Date:	₩.	

								<i>5</i> /(12	QA Closed:	Dat	te:		
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	•				Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Quality		
NCR N	lo				Use-as-is Work Order Update	Therr	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other		
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &				
Cause	Date	` Step	Qty	٠ (	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	n QC Inspector		
Doc/Data					•								
quip/Tooling		1											
Operator		<u> </u>											
Material													
Setup										i			
Other													
Process													
Supplier													
Fraining													
Jnapproved		<u> </u>											
					F.	<b>AULT CATE</b>	GORY						
Landin	g Gear				General				•				
	Bending				Bend	Grain			Ovalized		Pressure/Forced		
	Centre No	ot Concer	ntric to (	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure		
<u> </u>	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld		
	Crushed/0	Crimped.			Burrs	Instruct	tions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
L	Cuffs			L	Contamination	Mainte	enance		Part Moved				
L	Heat Trea	t			Countersink	Mislabe	eled		Positioned \	Vrong			
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	'Surge	Other		
	Ripples in	Bend			Drill Holes	Offset			-	·			
	Torque W	aves in E	xtrusion	n [	Drawing	Out of	Calibration						
	Turning S	equence		-	Finish	Out of	Sequence						
Γ	Wave/Tw	ist in Tub	ne		Folio	Outside	Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-16-12 9:47:04 AM

Work Order ID: 93503	0.242					Start D	ate: 11/16/12	,	Required Date: 11/16/12
Parent Item: D350-600 Parent Item Name: Spacepool	1, RH, AS350/355						<b>2ty:</b> 1.00	_	Required Qty: 1.00
MS21042L3	Purchased	No		150	Each	2,220.0000	2	2	
Nut \\	Purchaseu	. 10				,	-1-123W		
		Loca	ti <u>on</u>	Loc Qty		Loc Code			
A July of Sta	1 227	316		501					
	· 105 A		122452	501					
	y re	ST30	0	225					r
1 III It atta			117885	32					
1 11/1 010 3			119017	55					
90			119075	138					
\ \		ST31		1173					
			123265	1173					
\		ST31		321					
\			122141	321					
MS27039 <sub>7</sub> 08-11	Purchased	No		150	Each	610.0000	2	2	
Screw								40.4	
\		Loca	<u>tion</u>	Loc Oty		Loc Code			
\		309		100					
\			122441	100					
		ST29	92	30					
			120833	30					•
\		ST3	)7	480					
			123352	480					
MS27039-1-15	Purchased	No		150	Each	101.0000	2	2	
Screw							LEUGUAN		
\		Loc	<u>ation</u>	Loc Qty		Loc Code			
\		ST2	91	3					
\			118574	2					
\			119736	1					
`	<b>v</b>	ST3	05	98					
			123352	98					

										DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UPI	DATE			
										QA Closed:	Date:	
Work Ord	er:					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part I						Rework Scrap Use-as-is Work Order Update	1 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
							AULT CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landi	Bending Centre Not Concentric to O/S BOM/Route					BOM/Route Broken/Damaged Burrs Contamination Countersink	<b>—</b>	ion Incomplete cions Incomplete/l enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-16-12 9:47:04 AM

Work Order ID:	93503								N.
Parent Item:	D350-600-242					Start D	ate: 11/16/12		Required Date: 11/16/12
Parent Item Name:	Spacepod, RH, AS350/355					Start	Qty: 1.00		Required Qty: 1.00
NAS1515H3 Washer	Purchased	No		150	Each	283.0000	2	2	
1	sulled 130780 DST		Location	Loc Oty		Loc Code			
1/1/	man 1 ) ) >>		ST277	32					
/ // // / / / / / / / / / / / / / / /	all zelles		119438	2					
1 /2/			120518	26					
	Ju 1		121415	. 4					
\			ST297	251			-		
\			123301	251					
D3186-4	Manufactured	No		110	Each	0.0000	1	1	
Spacepod Door, RH									
D3187-2\	Manufactured	No		110	Each	1.0000	1	1	
Spacepod Floor							and the second second		
\			<b>Location</b>	Loc Qty		Loc Code			
\			ST241A	1					
\			59579	1					
A3235-020-935	Purchased	No		110	Each	312.0000	8	8	
Washer - Countersunk	1 di chased						Ci Transcon		
			Location	Loc Oty		Loc Code			
\						Loc Code			
\	S		ST280	312					
			106150	312					

												DQA:	Date:			
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR!	AANCE / UPDA		•				
		<u>.</u>										QA Closed:	Date:			
Nork Ord	er:			•			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I							Rework Scrap Use-as-is Work Order Update			Machining noforming	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root			-	1	Dos	crir	otion of work order update		nitial	Action	2	Sign &				
Cause		Date	Step	Qty	Desi	-	r Non-conformance	1	ief Eng	Descrip		Date	Verification	QC Inspector		
oc/Data																
quip/Tooling																
perator																
laterial																
etup																
ther			-		:											
rocess												]				
upplier																
raining																
napproved																
							F	AUL	T CATE	GORY						
Landi	ng (	Gear			_		General					-		_		
	L	Bending			ļ		Bend	L	Grain			Ovalized	<u></u>	Pressure/Forced		
	L	Centre No	t Concer	ntric to	o/s		BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	L	Cracks					Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct	Weld		
	Crushed/Crimped. Burrs					Burrs		Instruct	ions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs Contamination						Contamination		Mainte	nance		Part Moved				
	Heat Treat Countersink						Countersink		Mislabe	led		Positioned V	Vrong			
	Inspection Strip in Tube Cut Too Short						Cut Too Short		Misread	1		Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes						Drill Holes		Offset							
		Torque W	aves in E	xtrusio	n [		Drawing .		Out of	Calibration						
	Turning Sequence Finish								Out of Sequence							

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV. E

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY and SR00099NY
REF. EASA STC EASA.IM.R.S.01292

### Purpose:

The purpose of this DSI is to provide the parts and instructions to convert a D130-780-041/-042 Spacepod™ to a D350-600-241/-242 Spacepod™ kit.

Parts List:

Q-9	1	QTY -012	Part Number	Description
	X		DSI9529-011	Spacepod Conversion Kit, LH
	T	X	DSI9529-012	Spacepod Conversion Kit, RH
		2	D2174-041	Web Assembly B 79 468 & B
-	£	***		Decal 886719 98
<u> </u>	1		D2985	1 2 2 2 2
· 🗀	1		D2187-1	Floor 858591 4B
	L		D3187-2	Floor 13 5 9 5 7 7 9 18
	1.		D3567-1-	Decal B 48724 1B
			D3567-2	Decal B 50373 15
	1		D4332=4	Decal P + 449
П		<b>FE</b> 154	D4332-2	Decal 37 866 444 30
$\Box$				
$\Box$	8	<b>8</b> .8.	AN3-3A	Bolt M 122800 , 15
4	8		AN3H4	Bolt 3 x m 11689715 x m 1237571
	36		AN525-10R7	Screw M123603 1
	h		AN526C832R14	Screw M 104916 (B)
$\vdash$	7		MS24894S67	Screw M 11 5 0 16 11 16
	t		MS24694S69	Screw M 112 49 2 46
	16		A3235-020-935	Washer 116150 11
	4		NAS1149DN832J	Washer (Alternate AN960JD8) M 123 3 4 8 9 B
	16		NAŞ1149DO332J	Washer (Alternate AN960JD10L) M 122973, 46
	8	18	NAS1149DO363J	Washer (Alternate AN960JD10) M 123 24 8 19
	1		MS21042L08 '	Nut M/22/41 B
<u> </u>	16		MS21042L3	Nut M123265 1B
_	16		AKS7-1032-130 ALS 7-1032-130	Insert M 1 22 7 6 3 1 4 h
-	Ť	11	D350-600	Kit Paperwork

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

D. SHEPHERD (DE # 02)

DATE: CERT. NO.: SH93-88 ISSUE NO .:

Α	NEW IS	SSUE		DC	11.02.04
REV.		]	DESCRIPTION	BY	DATE
DESIGN		SC	DART AEROSPA HAWKESBURY, ONTARI		
CHECK		<b>\$</b> .	DRAWING NO.	,	REV. A
MFG. A	PPR.	N/A	DSI 9529		SHEET 1 OF 2
APPRO	VED	-//	TITLE		SCALE
DE APF	·R.	4	SPACEPOD™ CONV	ERSI	NC
DATE	11.0	2.04	COPYRIGHT © 2011 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY DEPOSE OR COPIED OR COMMUNICATION FROM DART AET WRITTEN PERMISSION FROM DART AET	ON THE EXPRES	S CONDITION THAT IT IS

												DQA:	Date	e: _	
NCR:	Yes	/ No					WORK ORDER NON-C	COI	NFOR	MANCE / UP	DATE		-		
							· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date	e:_	
Work Ord	ler:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
							Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing				4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Desc	crip	otion of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification		QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved															
							F/	AUL	T CATE	GORY					
Land	ing (	Gear			_		General					_	_		
	-	Bending Centre No	it Concer	ntric to (	0/5		Bend BOM/Route		Grain Hardwa	re		Ovalized Over/Under	tolerance	_	Pressure/Forced Temperature/Cure
		Cracks			-''-	_	Broken/Damaged	$\vdash$	1	on Incomplete		Part Incorred	-		Weld
	F-1			Burrs	H	1	ions Incomplete/	Unclear —	Part Lost/Mi	<b>⊢</b>		Wrong Stock Pulled			
	Cuffs Contamination				r	Mainte			Part Moved						
Heat Treat Countersink					Г	  Mislabe	led		Positioned V	Vrong					
Inspection Strip in Tube Cut Too Short					Cut Too Short	Г	Misread			Power Loss/			Other		
		Ripples in	Bend				Drill Holes	Г	Offset		<b>L</b>		- L		
	Torque Waves in Extrusion Drawing					Drawing	Out of Calibration								

Out of Sequence
Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

#### Procedure:

- 1) Remove the D3547-1 Bracket complete with D3554-7 Ball Stud and D3550-1 Strut from the D130-780-041/-042 Spacepod™ installation. Retain for reinstallation.
- 2) Remove the D130-780-041/-042 Spacepod™ from the EC130 aircraft per ICA-D130-780 Section 52.1.
- 3) Remove the floor-from the D130-780-041/-042 Spacepod™ by removing the (28) AN525-10R7 screws.
- 4) Install the D130-780-041/-042 Spacepod™ in the AS350 aircraft per IIN-D350-600.
- 5) Remove and replace the existing EC130 Spacepod™ decals as follows:

D2985 replaces D3837-1 D3567-1 replaces D3837-3 D3567-2 replaces D3837-4

- 6) Install D4332-1/-2 placard next to the ID plate on the door of the Spacepod™.
- 7) Insert FMS-D355-600 into the Rotorcraft Flight Manual.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: D. SHEPHERD (DE # 02)

DATE: CERT. NO.: ISSUE NO.: 11.02.04 SH93-88 6

DESIGN	SC	DART AEROSPACE LTD	
DRAWN -	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<b>8</b> 5.		REV. A
MFG. APPR.	N/A	DSI 9529 SHEET	2 OF 2
APPROVED	4	7.7.	SCALE
DE APPR.	4	SPACEPOD™ CONVERSION	NTS
DATE 11.0	2.04	COPYRIGHT © 2011 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND COMPOENTAL AND IS SUPPLIED ON THE EXPRESS CONDITION NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON I WRITTEN PERMISSION FROM DART AEROSPACE LTD.	THAT IT IS WITHOUT

										DQA:	Date	
NCR: Y	es / No				WORK ORDER NON-	CON	FORN	MANCE / UP	DATE			
		E 12 18 05								QA Closed:	Date	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	7 I		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	o				Scrap	11	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		,			Use-as-is	] [	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o			·	Work Order Update	╛┃		Large Fab	Composite		Supplier	
Root				Descr	iption of work order update	ln	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling												
perator												
1aterial												
etup			ļ			1						
ther			ļ									
rocess												-
upplier												
raining												
napproved												
				•		FAULT	CATE	GORY		•		
Landin	g Gear				General			<u> </u>				
ſ	Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced
Ţ	Centre N	ot Conce	ntric to	o/s	BOM/Route		lardwa	re		Over/Under	tolerance	Temperature/Cure
ſ	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
Ī	Crushed/	Crimped			Burrs		nstructi	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H-/FORMS	/Ouglity	Accurance	annroyad	QA/NCRWO Rev G
11./101111112	/ Quanty	Maaul anice	lappi oved	CHAIRCHARD VEA O

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

tatus	Jtem ID	Rev	Name	Start Date			Date Sec	rap i	ip Qua	mmend i	NEC IISortme C	msean Ty	l Per C	ch to 'or	re C∌ Li	ast #
	A3235-020-935		Washer - Counter	6/26/09	8./.	Ea	110	0	0.0	3)	27	0 M			3/	/2
	AKS4-1032-130		Inserts	6/26/09	28./.	Ea	110	0	0.0	a)	4	0 M			7/	/0
	AKS4-1032-130	717	Inserts	6/26/09	(10)	Ea	160	0	0.0	۵	33	0 M			7/	/0
	AN3-10A 117313	Hare	Bolt	6/26/09	(2)	Ea	160	0	0.0	[a]	21	0 M			17	2/
	AN3-3A (16924		Bolt	6/26/09	4)	Ea	160	0	0.0	3)	19	0 M			17	2/
	AN3-6A 116704		Bolt	6/26/09	(4)	Ea	160	0	0.0	<u>a</u> )	20	0 M			17	2/
	AN525-10R7	42-66-	Screw 2004	6/26/09	<b>3</b> 8	Ea	160	Ō	0.0	a	23	0 M	i ¦		17	2/
71.	AN526C832R14	11011-	Screw	6/26/09	(8 <u>)</u>	Ea	160	0	0.0	: a)	25	0 M			17	2/
	AN526C832R24	104916	screw	6/23/11	4	Ea	160	0	0.0	31	0	0 M			6/	/2
	AN5-5A	110865	Boit	6/26/09	1	Ea	160	0	0.0	ļ	22	0 M			17	2/
$\langle$	D130-780-013 5349	23 n=432	Switch Relocation	12/05/09	1	) Ea	160	0	0.0	<u>(i)</u>	34	0 M			12	2/
	D130-780-044		Spacepod Door As	12/05/09	1	Ea	110	0	0.0	(a)	1	0 M			17	2/
	D2179	ing terus in the area to the a	Doubler	3/24/10	2	. Ea	110	0	0.0	aj	0	0 M			3,	/2
energianismus van eene	D2237		Striker Plate	12/05/09	2	. Ea	110	0	0.0	l a'i	6	0 M	<u> </u>		1	2/
	D3015-3 ( 75 2 (	0 4650	Locknut	12/05/09	(î.)	. Ea	160	0	0.0	.3)	18	0 M		<b>-</b>	1	2/
	D3188-6 _		Spacepod Body	4/07/10	1	. Ea	110	0	0.0	3)	0	0 M			4,	/0
	D3538-1		Hinge Bracket	12/05/09	2	. Ea	110	0	0.0		8	0 M			1	2/
	D3547-1 5795	1 3000	Bracket	12/05/09	1.	) Ea	160	0	0.0		15	0 M			1	2/
	D3550-1 660(9		Strut	12/05/09	1	) Ea	160	0	0.0		16	0 M			1	2/
ann achtadóineánna ath in	D3554-7 65/23	2	Ball Stud	12/05/09		. Ea	160	0	0.0	i	17	0 M			1	2/
	D3798-042 53507		Spacepod Floor	12/05/09	1	. Ea	160	0	0.0	a	14	0 M	: !		1	2/
***************************************	D3815-041, \$656	4-56	Web Assembly	12/05/09	(2)	. Ea	160	0	0.0		12	0 M			1	.2/
	D3815-5 613/8	54533	Packer	12/15/09	<b>3</b>	. Ea	160	0	0.0	a'l	0	0 M			1	2/
***************************************		8246231	Decal	12/05/09	(1.)	. Ea	160	0	0.0	a)	13	0 M			1	2/
	MS20426AD4-5	14001	Rivet	6/26/09	4		110	0	0.0	<u> </u>	7	0 M			1	2/
	MS21042L08		Nut	7/06/09	4	. Ea	110	0	0.0		11	0 M			6	5/2
***********	MS21042L3 74 112365	116549	Nut /SX	6/26/09	22	. Ea	160	0	0.0		31	0 M	<del> </del>	-	1	2/

Printed 11/16/12

2/11/16 5

Page 1 of 2

DQA:	Date:	,	d.	<b>S</b>	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

											QA Closed:	Dat	te:			
Work Orde	r:			DISPOSITION		AGAINST DEPARTMENT/PROCESS										
Part No.					Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab		Water Jet Engineering Prod. Eng. Coor. Quality					
NCR No.					Use-as-is Work Order Update	],		noforming Large Fab	Finishing Composite			re/Packaging Supplier		Other		
Root				Descri	ption of work order update	lni	itial	Ac	tion 🗈	<u>.</u>	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription		Date	Verification	n	QC Inspector		
Doc/Data																
quip/Tooling						· .										
Operator										•	'					
Material									~							
Setup													ļ			
Other						1										
Process													İ			
Supplier		<u> </u>														
Training											· ·					
Jnapproved			<u>.</u>			1				pi.	ī.					
					F	AULT	CATE	GORY								
Landin	g Gear			<b></b>	General							,				
	Bending			<u> .</u>	Bend		irain		•		Ovalized		Pr	ressure/Forced		
	Centre No	ot Concer	ntric to (	o/s	BOM/Route	H	lardwa	re			Over/Under	tolerance	L∐T€	emperature/Cure		
	Cracks				Broken/Damaged	-	•	on Incomplete		Ĺ	Part Incorre	ct	Щv	/eld		
Ĺ	Crushed/	hed/Crimped. Burrs				Ir	nstructi	ions Incomplete/	Unclear		Part Lost/Mi	issing	∐_\w	rong Stock Pulled		
	Cuffs				Contamination	∐^	/lainte	nance		L	Part Moved					
	Heat Trea	it			Countersink	$\square^{\triangleright}$	⁄islabe	led		<u> </u>	Positioned V	Vrong				
Ĺ	Inspection	n Strip in	Tube		Cut Too Short	$\square$	/lisread	I			Power Loss/	Surge		ther		
	Ripples in	Bend			Drill Holes		Offset				· · ·					
Į	Torque W	aves in E	xtrusior	۱ _	Drawing		ot of C	Calibration								
Į	Turning S	equence			Finish		ot of S	equence								
	Wave/Tw	ist in Tuk	ne .	1	Folio		)utside	Dimensions								

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Status Production Item ID	Rev	Name	Start Date	antity	/ JON	op Date Sec	rap ı	p Quai	nmend N	C IISortme (	Offsean Ty	1 Per C	ch to	ore C) La	st lid D
MS21042L5	116 105	Nut	6/26/09	$\binom{1}{2}$	. Ea	160	0	0.0	[a]	32	0 M			12/	12
MS21059L3 117887	173749	Nut Plate	12/15/09	10.	)Ea	160	0	0.0	.e.)	0	0 M			12/	' <b>12</b>
MS24694-S54	117460	Screw	12/15/09	6	Ea	160	0	0.0	<u>a)</u>	0	0 M	: :		12/	12
MS24694-S67 (SX) 114341	106/66	Screw	6/26/09	$\binom{7}{2}$	Ea	160	0	0.0	43	24	0 M			12/	/ 12
MS24694-S69	112492	Screw	6/26/09	$\mathcal{Q}^{1}$	. Ea	160	0	0.0	<u>.</u>	26	0 M			12/	/ 12
NAS1149D0332J	1180718	Washer	6/26/09	16.	) Ea	160	0	0.0	a	29	0 M			12,	/ 12
NAS1149D0363J	117291	Washer	7/06/09	14.	.) Ea	160	0	0.0	<u>.a)</u>	28	0 M			12,	/ 12
NAS1149D0563J	17759	Washer	7/06/09	(3	). Ea	160	0	0.0	al	30	0 M			12,	/ 12
NAS1149DN832J		WASHER	6/26/09	4	∴ Ea	110	0	0.0	<u>a</u>	10	0 M			6/2	2 12

54 12/m/10 130-780-01! 56509

											QA:	Dat	:e: _	•				
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UPDATE		•		_					
							`			Dat	Date:							
Nork Order: DISPOSITION									AGAINST DEPARTMENT/PROCESS									
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Scrap - Machining Small Fab Use-as-is Thermoforming Finishing							Engineering Quality Other				
Root					Desc	cription of work order update	- 1	nitial	Action :	Sign	&							
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description -	Dat		Verification	۱	QC Inspector				
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining								a.						,				
						F	AUL	T CATE	GORY									
Land	ng (	Gear			_	General						_						
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear nance iled	Ovalize Over/L Part In Part Lo Part M Positio Power	Inder correc st/Mi oved ned V	issing		Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled Other				
		Turning Sequence Finish						Out of Sequence										

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Item ID	Rev	Name	Start Date		oren a company of the					12	0 M	,		,	12,
AN526C832R10		Screw	6/26/09	10	⊏d	110		0.0	,â.)	14			<u>.</u>		
AN526C832R14	Fire	Screw	6/26/09	2	Ea	110	0	0.0	e)	19	0 M				12,
D2228		Bracket Plate	12/05/09	4	Ea	110	0	0.0	<u>d</u> )	11	0 M				6/2
D2464-1250	* 3 -	Neoprene Seal	12/05/09	1	Ea	110	0	0.0	3)	2	0 M				12/
D2585	241	Mounting Channel	12/05/09	, 2	Еа	110	0	0.0	à)	5	0 M				12,
D2586	. 46-	Door Latch	12/05/09	2	Ea	110	0	0.0	ď	4	0 M				12,
P2589	5894	Keys, Key Chain,	12/05/09	1	Ea	140	0	0.0	(a)	20	0 M				12,
D2621		Latch Plate, 350 S	12/05/09	2	Ea	110	0	0.0	31	6	0 M				12,
D2857-1	-	Hinge Bracket	12/05/09	1	Ea	110	0	0.0	33	9	0 M				12,
D2857-2	The state of the s	Hinge Bracket	12/05/09	1	Ea	110	0	0.0	رف	10	0 M				12
D3015-3		Locknut	12/05/09	1	Ea	110	0	0.0	: <u>d</u> ]	18	0 M		:		12
D3186-4	***************************************	Spacepod Door, RH	12/05/09	1	Ea	110	0	0.0	(a)	1	. 0 M				12
D3552-7	3700	Door Prop	12/05/09	(1.)	Ea	140	0	0.0	[4]	21	0 M				12
D3554-7		Ball Stud	12/05/09	1	Ea	110	0	0.0	(a)	16	0 M				12
D3557-1		Bracket	12/05/09	1	Ea	110	0	0.0	2)	15	0 M	•		1	12
D3837-4		Decal	12/05/09	1	Ea	110	0	0.0	<u>.a)</u>	3	0 M				12
MS21042L08		Nut	6/26/09	14	Ea	110	0	0.0	(3)	14	0 M				7/
MS21042L3		Nut	6/26/09	2	Ea	110	0	0.0	.3)	8	0 M				12
MS27039-08-11		Screw	6/26/09	2	Ea	110	0	0.0		22	0 M				7/
MS27039-1-15		Screw	6/26/09	2	Ea	110	0	0.0	a	6	0 M	•	, ; ;		12
NAS1149D0363J	***************************************	Washer	9/03/09	2	. Ea	110	0	0.0	<u>a</u>	7	0 M	•		:	12
NAS1149D0563J	<del>-</del>	Washer	9/03/09	1	. Ea	110	0	0.0	, à î	17	0 M				12
NAS1149DN832J		WASHER	9/03/09	16	. Ea	110	0	0.0	2)	13	0 M.	•			7,
NAS1515H3		Waşher	6/26/09	2	. Ea	110	n	0.0	ها	24	0 M.				7,

13/11/61

DQA:	Date:	
·		

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date			
Work Ordei	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS			
Part No.					Rework Scrap Use-as-is	- I	Skid-tube Machining noforming	Crosstube Small Fab Finishing	┥	Water Jet d. Eng. Coor. re/Packaging	Quality		
NCR N	0				Work Order Update		Large Fab	Composite	<u></u>	Supplier			
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty	•	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling													
Operator	-												
Material	-												
Setup	-							•			•		
Other	-							نو سلاد					
Process	-												
Supplier Training	-	1											
Jnapproved	-												
onapproved	1	1	LJ			AULT CATE	GORY		<u>I</u>	1			
Landin	g Gear				General	AOLI CAIL	<u> </u>			· · · · · · · · · · · · · · · · · · ·			
Γ	Bending				Bend	Grain			Ovalized	Г	Pressure/Forced		
<u> </u>	Centre No	ot Concer	ntric to (	o/s	BOM/Route	Hardwa	are	* `	Over/Under	tolerance	Temperature/Cure		
<u> </u>	Cracks				Broken/Damaged	<b>├</b> ──┤	tion Incomplete		Part Incorre	<u> </u>	Weld		
	Crushed/	Crimped.			Burrs	<b>—</b>	tions Incomplete/	/Unclear	Part Lost/M	<b></b>	Wrong Stock Pulled		
-	Cuffs	,			Contamination	_	enance		Part Moved		<u> </u>		
-	Heat Trea	at		<u> </u>	Countersink	Mislabe	el <b>ed</b>		Positioned \	<b>N</b> rong			
·	Inspection		Tube		Cut Too Short	Misrea			Power Loss		Other		
·	Ripples in	•			Drill Holes	Offset		<b>L</b>		- <u>L</u>			
	Torque W		xtrusion	,	Drawing	Out of	Calibration						
	Turning S	equence			Finish	Out of	Sequence	``					
	Wave/Tw	ist in Tuk	10		Teolio	Outside	a Dimensions	1			-		